Rear Panel

Replacement

1. Remove the related parts.
   - Rear bumper
   - Rear bumper beam
   - Trunk lid lock and its attachments
   - Other related parts
   - Rear and side trim panels
   - Taillights

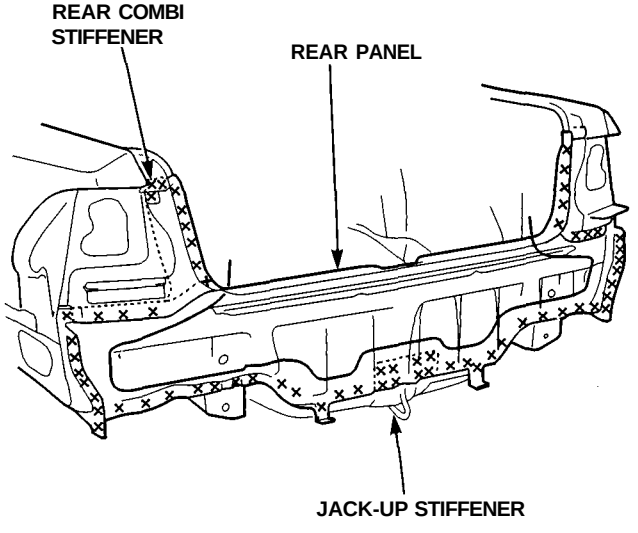
2. Pull out and straighten the damaged area.
   - Pull out the related rear side inner panel, rear floor, rear side frame, and other damaged parts with the frame straightener.
   - Attach the vehicle to the frame straightener by tightening the underbody clamps located at the jack-up points on the bottom of the side sill and the side sill side flanges.

3. Cut and pry off the rear panel.
   - Cut along the bold line shown with a gas cutter or an air chisel and remove the rear panel.
   - Center punch around the spot weld imprints with the rear side outer panel and rear floor.
   - Drill holes using the spot cutter.

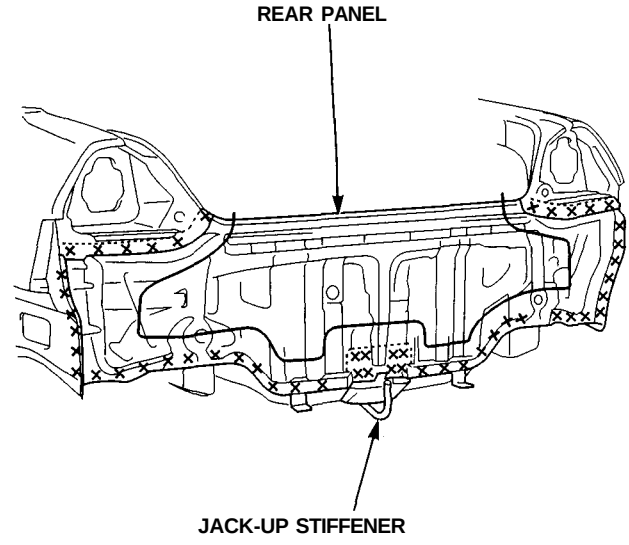
   NOTE: Be careful not to let holes penetrate through to the rear floor.

   - Remove weld flange with a chisel.

   Sedan:



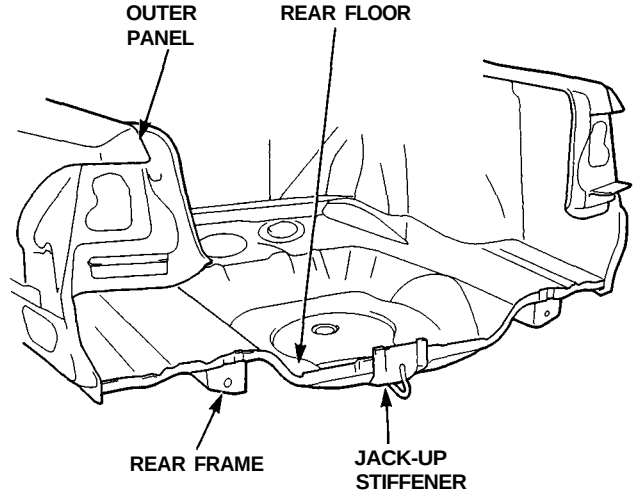
Coupe:



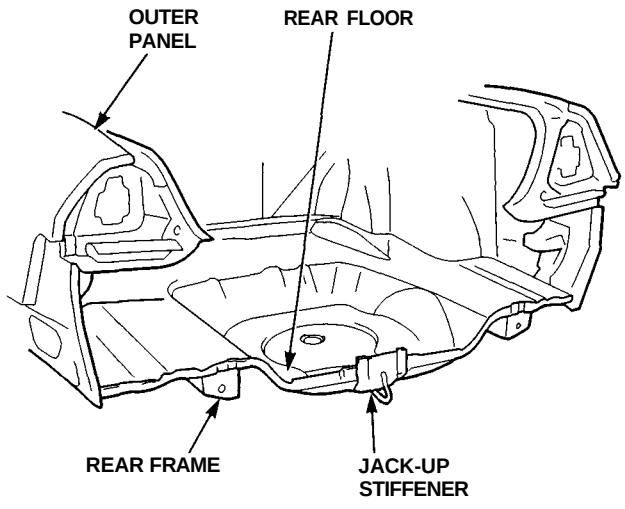
4. Straighten the related parts.
   Repair all cracks, holes or other defects by MIG or gas welding.

   WARNING **To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.**

Sedan:

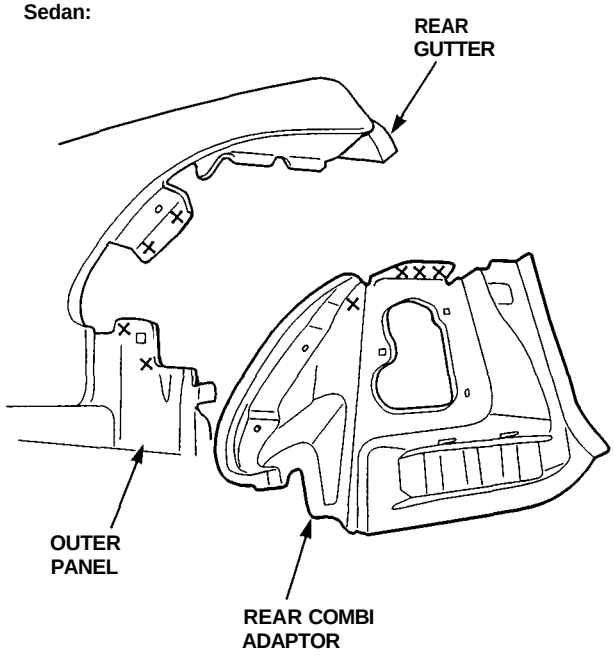


Coupe:



5. Check the outer panel for position and damage. Replace the rear combi adaptor (sedan) or side panel extension (coupe) if necessary.

Sedan:



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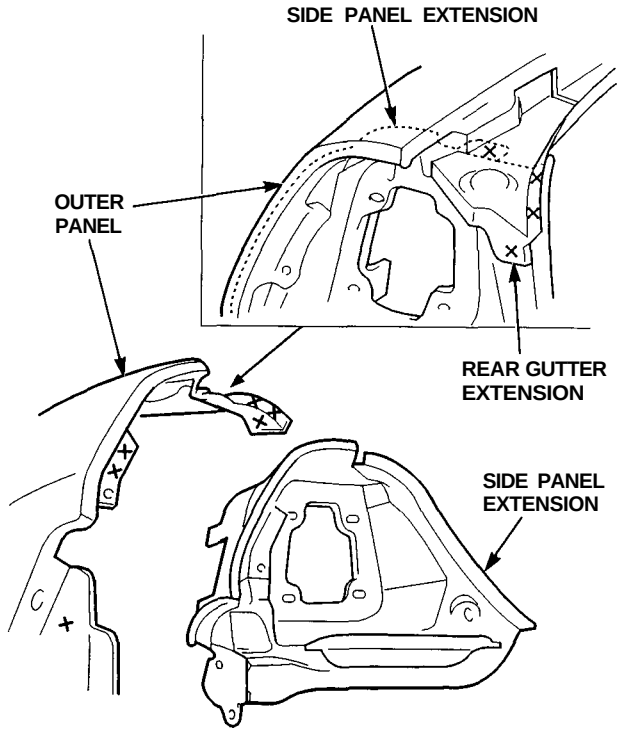


(cont'd)

Rear Panel

Replacement (cont'd)

6. Set the new rear panel and rear combi adaptor (sedan) or side panel extension (coupe).
   - Paint the inside of the rear combi adaptor (sedan) or side panel extension (coupe) and rear panel with the body color.

⚠ WARNING

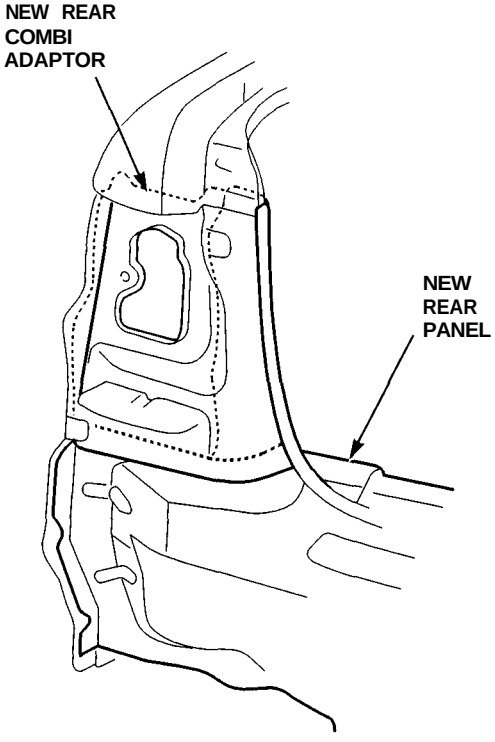
- **Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.**
- **Avoid contact with skin. Wear an approved respirator, gloves, eye protection, and appropriate clothing when painting.**
- **Paint is flammable. Store it in a safe place, and keep it away from sparks, flames, or cigarettes.**

   - Remove the undercoat from the welding section of the panels and expose the steel plate using a disc sander.

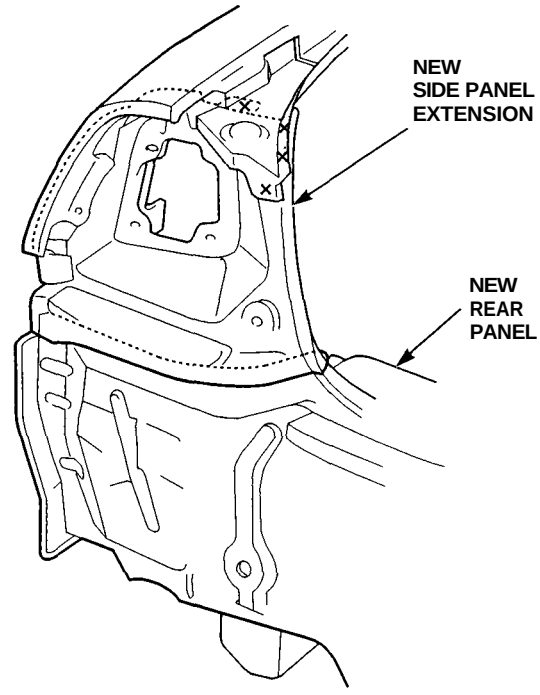
⚠ WARNING **To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting, or grinding.**

NOTE: Apply the spot sealer to the welding surface when spot welding.

Sedan:



Coupe:



   - Check the rear panel position using the body dimensional drawings (see section 6).

7. Tack weld the rear panel and rear combi adaptor (sedan) or side panel extension (coupe).
   - Weld the clamped sections for temporary installation.

⚠ WARNING **To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.**

8. Open and close the trunk lid to check for proper installation.

NOTE: Make sure the trunk lid locks securely.

Position the rear combi adaptor (sedan) or side panel extension (coupe) and rear panel in its correct position with the rear bumper and taillight installed.

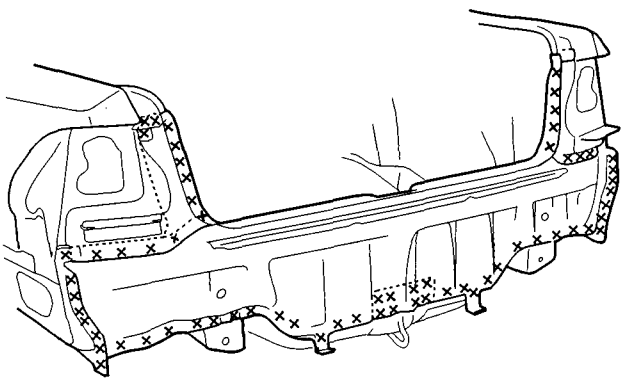
9. Perform the main welding.

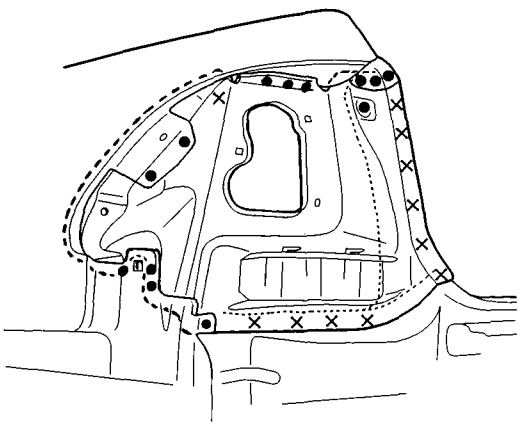
⚠ WARNING **To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.**

- Make 20% to 30% more spot welds than there were holes drilled.

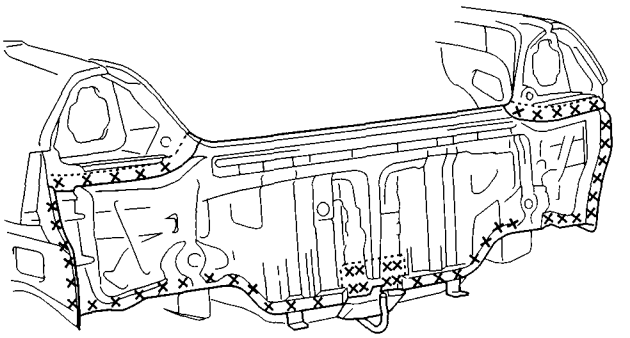
NOTE: If there isn't room for spot welds, compensate by using MIG welds.

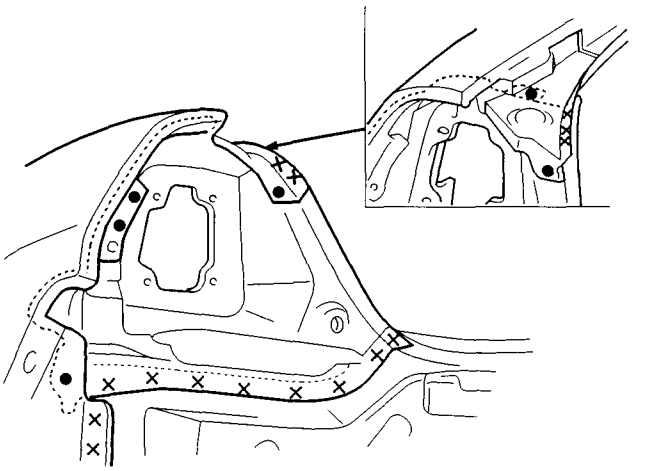
Sedan:





Coupe:





10. Finish the welding area.

- Level the welded acres with a disc sander, then even out high areas with a hammer. Be careful not to deform them.

⚠ WARNING **To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting, or grinding.**

- Even out the spot welded flange area with a hammer and dolly.

11. Apply the sealer (see section 5).

- Apply sealer to the rear side outer joint and around the taillight areas of the rear panel.
- Apply sealer to the rear panel and rear floor joint.

(cont'd)

Rear Panel

Replacement (cont'd)

12. Apply the paint. See Paint Repair section.

⚠ WARNING

- **Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.**
- **Avoid contact with skin. Wear an approved respirator, gloves, eye protection, and appropriate clothing when painting.**
- **Paint is flammable. Store it in a safe place, and keep it away from sparks, flames, or cigarettes.**

13. Apply anti-rust agent (see section 7).
    - Apply agent to the outer panel, rear panel and rear floor joint.
    - Apply agent to the inside of the jack position stiffener.

14. Install the related parts in the reverse order in which the were removed.

15. Inspect, check, and clean.
    - Adjust the clearance with the trunk lid, then adjust the level differences and fit. Check operation.
    - Test for leaks in the trunk compartment.
    - Clean the trunk floor.